

Work Order ID 66294

February 9, 2011 10:07:49 AM



Page 1

Item ID: D3602-1	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Angle					
Start Date: 2/10/11	Start Qty: 4.00		Cust Item ID:		
Required Date: 2/24/11	Req'd Qty: 4.00		Customer:		
Reference:					

Approvals:	Process Plan: <u>mt</u>	Date: <u>11-02-09</u>	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3602	Rev B								
100	FLOW WATER JET	0.00							
	Waterjet								
FLOW CNC Waterjet	Memo	0.00							
304 .040	1-Cut as per Dwg D3602 <input type="checkbox"/> Dwg Rev: <u>B</u> <input type="checkbox"/> Prog Rev: <u>B</u> <input type="checkbox"/> 2-								
	Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
QC	Memo	0.00							
Quality Control									

11-02-09

⑥

11-02-09

11 02 09 ⑥

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
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Item ID: D3602-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Angle

Start Date: 2/10/11

Start Qty: 4.00

Cust Item ID:

Required Date: 2/24/11

Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

W/4/25

11-04-25
(4)

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Work Order ID: 66294

Parent Item: D3602-1

Parent Item Name: Angle



Start Date: 2/10/11

Required Date: 2/24/11

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 07-02-27 JLM
IPP Rev:B 08-12-11 as per ECN08-577 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S20GA

Purchased

No

100

sf

149.5538

0.585

2.463158

4.



B11-2-9

304/316 .040 Sheet

Location

Loc Qty

Loc Code

MAT

149.5538

115953

21.6

116437

52.7538

116623

75.2

116623

6

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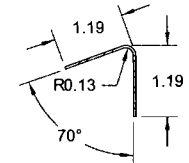
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

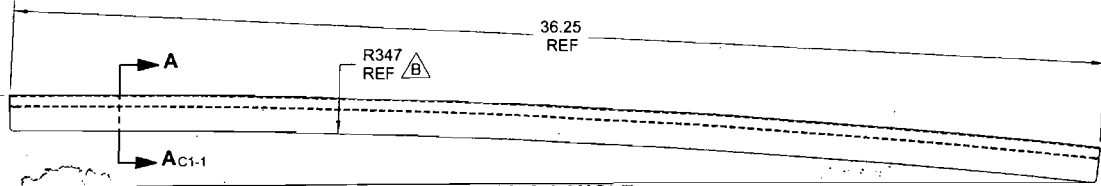
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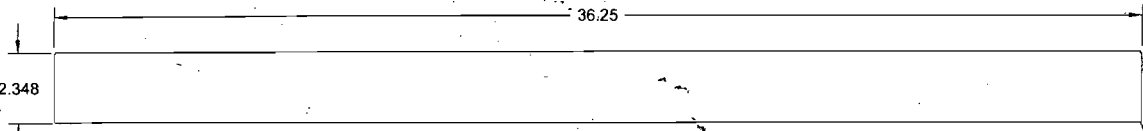
#66294



SECTION A-A
SCALE 2X



D3602-1 ANGLE
(MAKE FROM D3602-1F)



D3602-1F FLAT PATTERN

R0.13
TYP

RELEASED
09/03/11

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 20 GAUGE, 0.038 THICK, PER AMS 5513 OR AMS 5524, REF. DART SPEC. M304S20GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFY WITH DART P/N "D3602-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.97 lbs

B	ADDED ROUNDED SHAPE: R347 REF AND 3.05; 2.348 WAS 2.328. REF: NCR#09-014	MB	09.02.02
A	NEW ISSUE	MB	07.02.20
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.02.02		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3602
TITLE ANGLE
REV. B
SHEET 1 OF 1
SCALE NTS

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